Work Orde  January-02-13 2		169		*9	51	69*						Page 1
Revision ID:	D3121-241 Bearing Asser	nbly [		Accept		*N900	<b>040</b>	100	)* s	etup Star Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	1/14/13 1/14/13	Start Qty: 20,00 Req'd Qty: 20.00	*20* *20*			Cust Item II Customer:	D:		Ž.			
Approvals:	Process Pla	in: MLJ	Date: 13-01-07	Tooling:		Da	ite:		F	tun Star	I <i>Z</i> I	R1*
	QC:		Date:	SPC (Y/N)	) <b>:</b>	Da	nte:			Stop	` *N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										
D3121	Rev	/ E										
100 <b>*100</b> Hardinge		Hardinge CNC LATHE S	SMALL	0.00					100	ф.		~ 13°C,
Hardinge CNC Lathe	e Small		21-25 Cap as per Folio FA38	872-Deburr	13	-1-20						
*110 *110*		QC2- Inspect parts off m	achine FAI/FAIB	0.00					Icel			Day
QC Quality Control		Memo		0.00	/	3-1-20			100	— <del>У</del>		,
120 *120*		QC8- Inspect parts - seco	and check	0.00	0AS 14	13/01/2	,		سر مدار	_		
QC Quality Control		Мето		0.00	S-69	, = , = , ( \( \times_1 \)			100	) _ <i>y</i> }		

											DQA:	Date:	:
NCR:	Yes /	No				WORK ORDER NON-	CO	NFORM	MANCE / U	PDATE			
						•				,	QA Closed:	Date	•
Work Ord	er.				:	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	Τ-	Initial	Δ	ction	Sign &		
Cause	D	ate St	ep (	Qty	-	or Non-conformance		nief Eng		cription	Date	Verification	QC Inspector
Doc/Data				~			+			er i pero i	Dute	vermedelon	Qe mspector
Equip/Tooling	H			İ									
Operator	H												
Material	H					•							
Setup	H												
Other	H	j											
Process	H	-											
Supplier	П												
Training	H	į	ĺ										
Unapproved	П	:						:					
	<del>*************************************</del>						FAUI	LT CATE	GORY		· · · · · · · · · · · · · · · · · · ·	<del> </del>	
Landi	ing Gear					General							
	Ben	ding				Bend		Grain			Ovalized		Pressure/Forced
	Cen	re Not Co	ncentri	ric to O/	s 🗍	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	ks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crus	hed/Crim	oed.			Burrs	Г	Instruct	ions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuff	5				Contamination		Mainte	nance		Part Moved		<del>-</del>
	Hea	Treat				Countersink		Mislabe	led		Positioned \	Vrong	
	Insp	ection Stri	p in Tu	ube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripp	les in Ben	d			Drill Holes		Offset			<del>-</del>	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

														:-
Work Orde January-02-13		169		* <u>9</u> 51	69	*							Page 2	
Item ID: Revision ID: Item Name: Start Date:	D3121-241 Bearing Asser	<b>Start Qty: 20.00</b>	*20*	Accept		I900	040 ID:	100	)*	Setup	Start Stop	IV	S1* S2*	
Required Date: Reference:	: 1/14/13	Req'd Qty: 20.00	*20*		C	Customer:	•				~.			
Approvals:	Process Pla	ın:	Date:	Tooling:		D	ate:			Run	Start	!/	R1*	
	QC:		Date:			D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accep Qty	t Re	ject y	Reject Number	Insp. Stamp	- •
*130		Small Fab		0.00					100	)x			d/Sa	
Small Fab		Memo		0.00					100				- <del> </del>	R/
Small Fab		1-Press D31:	21-23 Bearing into D3121		21									/
140 * <b>14</b> 0*		QC5- Inspect part comple	eteness to step on W/O	0.00	5				10	X				
QC Quality Control		Memo		0.00 13.2	OC 1				COU					

150

Identify as per dwg & Stock Location: \$\frac{1}{2} \frac{1}{2} \fr

\*150\* Packaging

Packaging Packaging Memo

0.00

								DQA	i: Date:	
NCR: Ye	s / No				WORK ORDER NON-C	ONFORM	MANCE / UPDATE	QA Close	d: Date:	
Work Order	•				DISPOSITION		AGA	NINST DEPARTMEN	T/PROCESS	·
Part No					Rework Scrap Use-as-is Work Order Update	Therm	Machining Sma	shing Rec/St	Water Jet rod. Eng. Coor. ore/Packaging Supplier	Engineering Quality Quality Other
Root				Descript	tion of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty	or	r Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
oc/Data										
quip/Tooling										
Operator										
//aterial										

	FAULT CATEGORY								
Landing	Gear	General		_		-			
	Bending	Bend		Grain		Ovalized		Pressure/Forced	
1	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure	
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld	
	Crushed/Crimped.	Burrs	Г	Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
	Cuffs	Contamination		Maintenance		Part Moved		-	
	Heat Treat	Countersink		Mislabeled		Positioned Wrong			
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge		Other	
	Ripples in Bend	Drill Holes		Offset					
[	Torque Waves in Extrusion	Drawing		Out of Calibration					
	Turning Sequence	Finish		Out of Sequence					
	Wave/Twist in Tube	Folio		Outside Dimensions					

Setup
Other
Process
Supplier
Training
Unapproved

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Work Orde				*951	169*							Page 3	3
Item ID: Revision ID: Item Name:	D3121-24 Bearing As			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	1/14/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ! Customer:	D:							
Approvals:	Process	Plan:	Date:	Tooling:		ate:		]	Run	Start Stop	*N	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:				-	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	w/fub
160		QC21- Final Inspection -	Work Order Release	0.00									
*160*		Memo		0.00				ML	.5_\	3- (	2-S	<b></b>	

Quality Control

A13-62-21

											DQ	۸: Da	ate: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UPI	DATE				
									·		QA Close	d: Da	ate:	
Work Ord	er:			-		DISPOSITION				AGAINST DE	PARTMEN	IT/PROCESS		
Part I	No.	<del></del>				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet rod. Eng. Coor tore/Packaging Supplier		Engineering Quality Other
<b>,</b> Root					Descri	ption of work order update	i	nitial	Act	ion	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	on .	QC Inspector
Doc/Data														
Equip/Tooling														
Operator											;			
Material														
Setup														
Other										e.*				
Process														
Supplier						•							ļ	
Training													!	
Unapproved							1							
						F/	AUL	T CATE	GORY					
Landi	ng (	Gear				General		_						_
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (	o/s	BOM/Route		Hardwa	re		Over/Und	ler tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incor	rect		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/	Missing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Move	ed	•	
		Heat Trea	t			Countersink		Mislabe	eled		Positione	d Wrong		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Lo	ss/Surge	Г	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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### **Picklist Print**

January-02-13 2:29:34 PM

Work Order ID:

95169

Parent Item:

Comments:

Item Name

D3121-23

Bearing

D3121-241

Parent Item Name:

Component Item ID/

MDELRINR1.000

Delrin Round Bar 1"

Bearing Assembly

•

Replacement

Item ID

IPP Rev:A04.02.18New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Bin

Item

No

No

Primary

Location

Location MAT018

117985

Mfg/

Purch

Purchased

Manufactured

Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
	100	f	38.9658	0.052	1.04			

**Start Date: 1/14/13** 

Start Qty: 20.00

118392	12.5524	
122582	25.5994	
	130 Each	49.0000
<b>Location</b>	Loc Oty	Loc Code
ST235 .	49	•
66734	10	
75084	2 , ′	
01016	27	

38.9658

0.814

13-1-20 4.2 1 1 20 3/02/20

Required Date: 1/14/13

Required Qty: 20.00

Page !

B94697 (30x)
B95860 (38x)

B 965 79 (32)

										•	DQA:	Date	;
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE			
											QA Closed:	Date	•
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part	No.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	No.					Work Order Update			Large Fab	Composite		Supplier	
Root		Data	Chan	04	Des	ption of work order update	1	nitial		tion	Sign &	)/:'£' 4'	061
Cause	Г	Date	Step	Qty		 or Non-conformance	Cr	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling													
perator 1aterial	-												
etup		1							•				
ther			j										
rocess			•										
upplier	Г												
raining	Г												
napproved													
<u>-ii</u>	·	<b></b>	1	1		F	AUL	T CATE	GORY		<u> </u>		- I
Landi	ng (	Gear		· · · · · · · · · · · · · · · · · · ·		 General					<u>'.                                    </u>		·
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	Г	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped.	-		Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	eled		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset				_	•
		Torque W	aves in E	Extrusio	n	Drawing		Out of 0	Calibration			·	
		Turning S	equence			Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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DART AEROSPACE LTD	Work Order: 55/65
Description: Sealing Cal	Part Number: 133,21-25
Inspection Dwg: 3 12 1 Rev:	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.315	=.010	316			Stry	Vera
.230	-,001	.230				1
1.00	±.010	1.001				
.838	± 002	840				
-865	F-001	.866	/_			
RO63	~000	ROBO				
12.010	010	ROOS				
						,
•						
	DAG			l		

	V 5.0.		
Measured by:	\$ & 89	Audited by:	Preliminary Approval:
Date:	<u> </u>	Date:	Date:
	. 4	_ <u> </u>	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	L

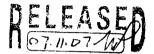
No.04.15



(<del>+</del>)

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DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED	APPROVED	DRAWING NO. REV. E
	417	I AN	D3121 SHEET 1 OF 10
DATE			TITLE SCALE
07.	11.07		BRACKET ASSEMBLY 1:2
Α		02.04.15	NEW ISSUE
В		03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146
С		04.02.17	ADD CLEARANCE; USE -241 BEARING
D		06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000
Ε		07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)



- D312	1-21	BOLT	(1	)
D312	1 - 24	1	•	•
BEAR	ING A	SSEME	3LY	(1)

D3121-11 BRACKET

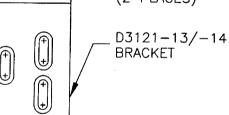
## D3121-041 BRACKET ASSEMBLY

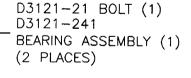
(REPLACES PREMIER P/N B30-23000-33)



#### D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)





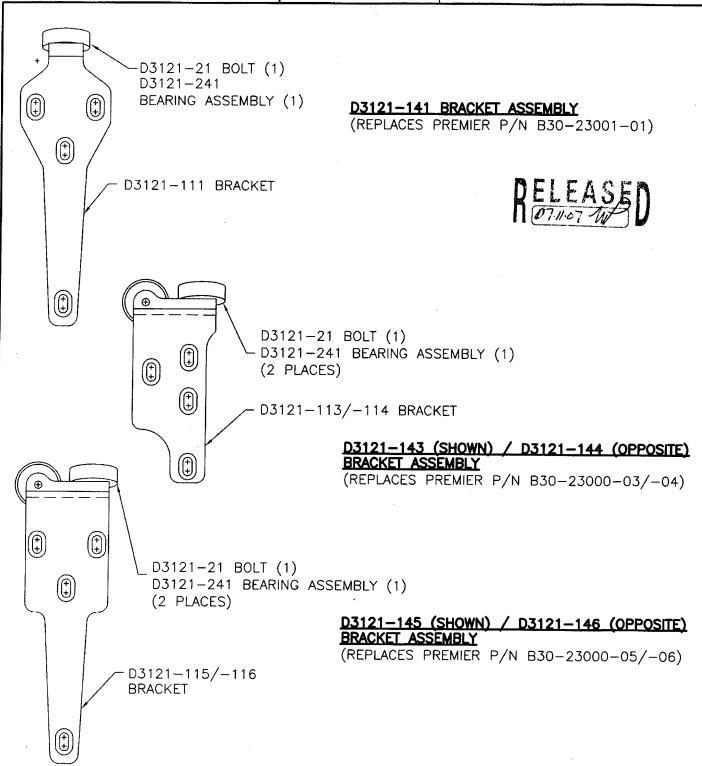
#### D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)





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CHECKED	APPROVED	DRAWING NO.	REV. E
#		D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

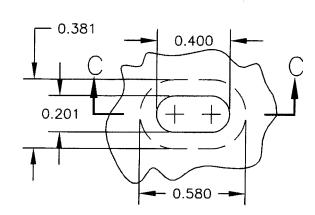


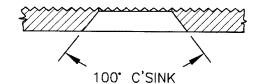
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CHECKED	APPROVED	DRAWING NO.	REV. E
1 4	<b>-</b>	D3121	SHEET 3 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

**DETAIL A:** SLOT DETAIL SCALE 2:1 VIEW ROTATED

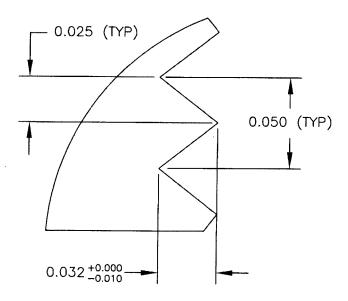




SECTION C-C

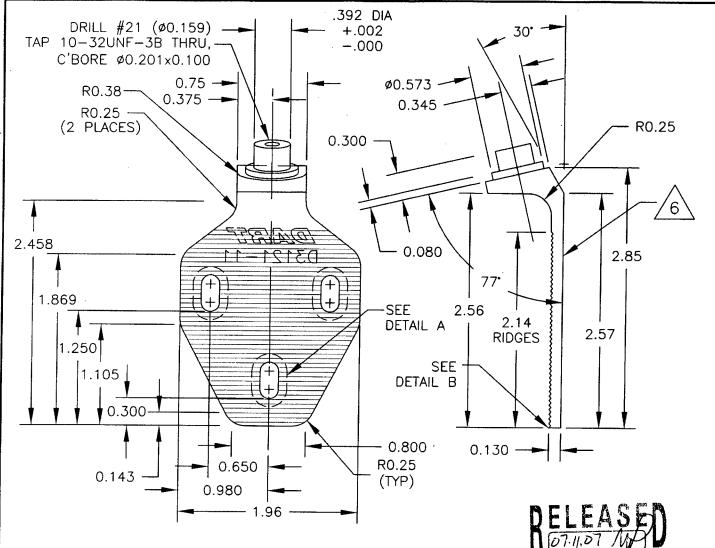
RELEASED

**DETAIL B:** RIDGE DETAIL PARTIAL SECTION SCALE 1:20





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CHECKED	APPROVED,	DRAWING NO.	rev. e
#	<b>-#</b>	D3121	SHEET 4 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1



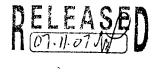
#### **D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
  MIN ULTIMATE TENSILE = 150 ksi
  MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
44	THE CONTRACT	D3121	SHEET 5 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



DART

D3121-13

1.220 - 1.800 -

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2.63

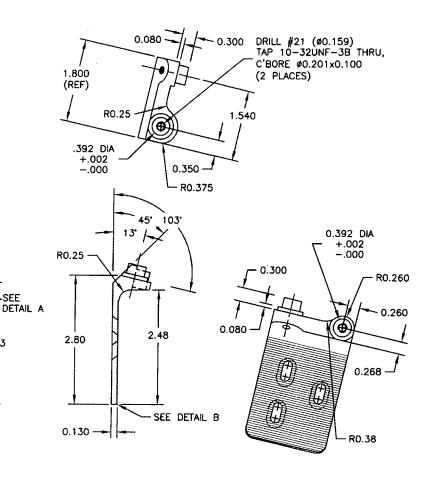
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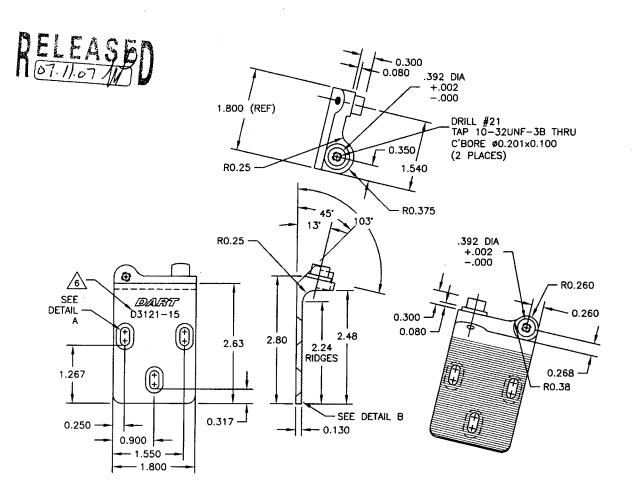


- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE STRENGTH = 150 ksi MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN 4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED,	DRAWING NO.	REV. E SHEET 6 OF 10
DATE	/*1	TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

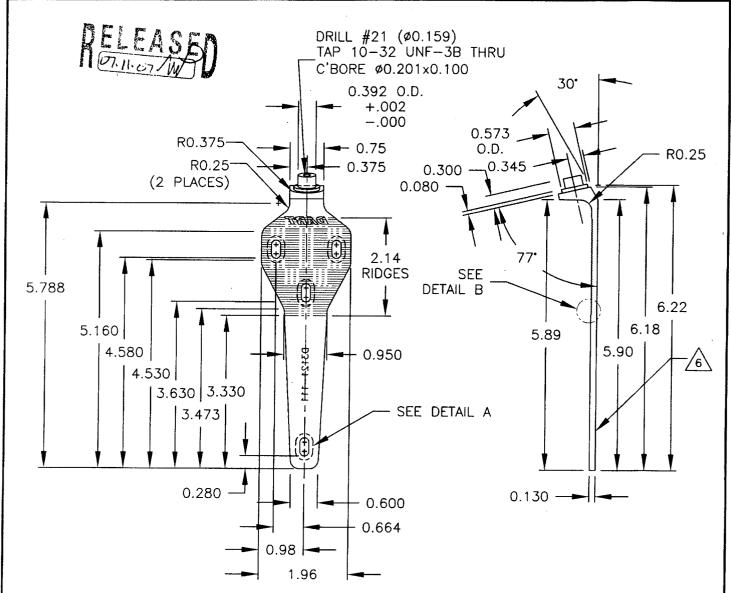


#### D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
44		D3121	SHEET 7 OF 10
DATE	1 1	TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2



#### **D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

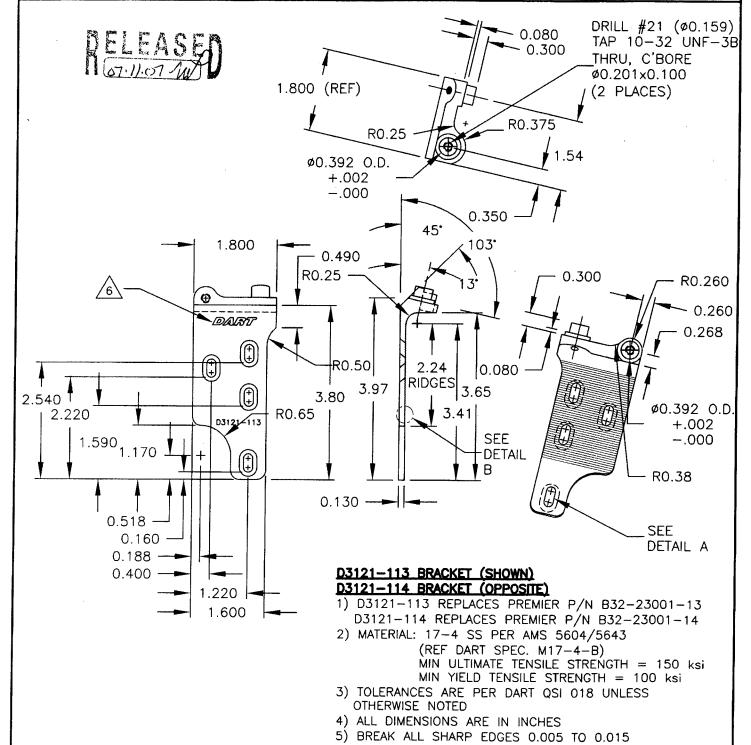
MIN YIELD TENSILE = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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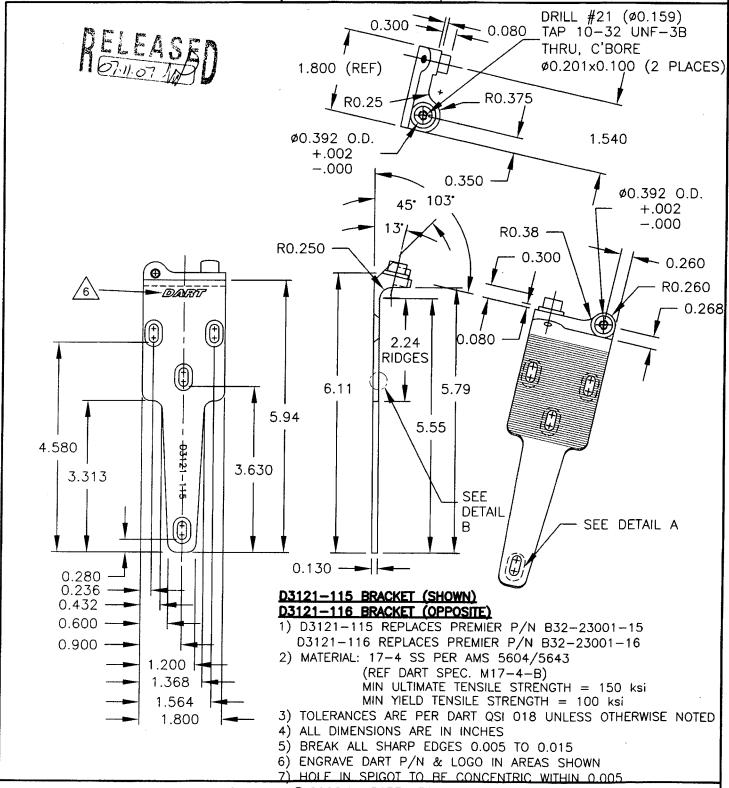
	DESIGN A DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED	APPROVED	DRAWING NO.	REV. E	
	#	-#	D3121	SHEET 8 OF 10	
ĺ	DATE		TITLE	SCALE	
	07.11.07		BRACKET ASSEMBLY	1:2	



6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



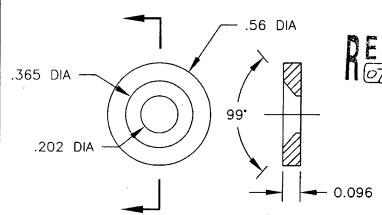
DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED,	DRAWING NO.	REV. E
#	<del> </del>	D3121	SHEET 9 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	. 1:2



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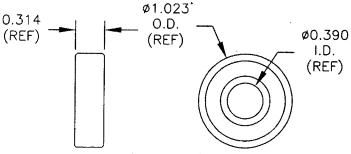


	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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	#	#	D3121	SHEET 10 OF 10
Ī	O7.11.07		TITLE	SCALE
			BRACKET ASSEMBL	<u>Y</u> 1:1



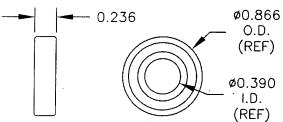
## D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



#### D3121-23 BEARING (SCALE 1:1)

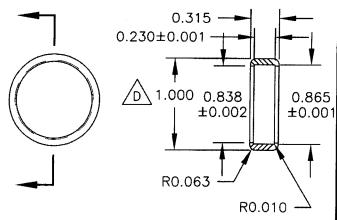
1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ

2) ALL DIMENSIONS ARE IN INCHES

# 0.375 TAP 10-32 UNF-3A O7.11-07 M 0.080 0.050 TO 0.060

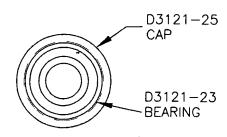
#### D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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